

Work Order ID 74806

74806

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October 6, 2011 2:35:32 PM

Item ID: D4034-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Upper Rib Assembly
 Start Date: 10/06/11 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 10/14/11 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/10/06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4034	B								
100	Weld per dwg A/R S.S. rod Batch: <u>M1157</u>	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- Assemble ribs to hoop and weld as per dwg DT9564								
	2- Weld bushing in rib and grind weld flush as per dwg								
110	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

11/10/07 (3x)

11.10.31

(3x)

11 10 31 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	<i>Basket cell</i>								
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten signatures and dates:
 11/11/09 (3x)
 11/11/15
 MF 11-11-11

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Picklist Print

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Work Order ID: 74806

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Parent Item: D4034-041

D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 10/06/11

Required Date: 10/14/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 *D4034-1* Rib		Manufactured	No			100	Each	0.0000	1	3			
									**	B 74122 - 3x			
D4034-3 *D4034-3* Rib		Manufactured	No			100	Each	2.0000	1	3			
									**	B 74918 → 2x B 72908 → 2x			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				2					
				58408				0					
				72253				2					
D4021-7 *D4021-7* Hoop		Manufactured	No			100	Each	7.0000	1	3			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				7					
				72252				7					
D4021-9 *D4021-9* Bushing		Manufactured	No			100	Each	72.0000	4	12			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				70					
				70333				14					
				72482				56					
				WA005				2					
				66437				2					

(3x)

(12x)

W/O:		WORK ORDER CHANGES					
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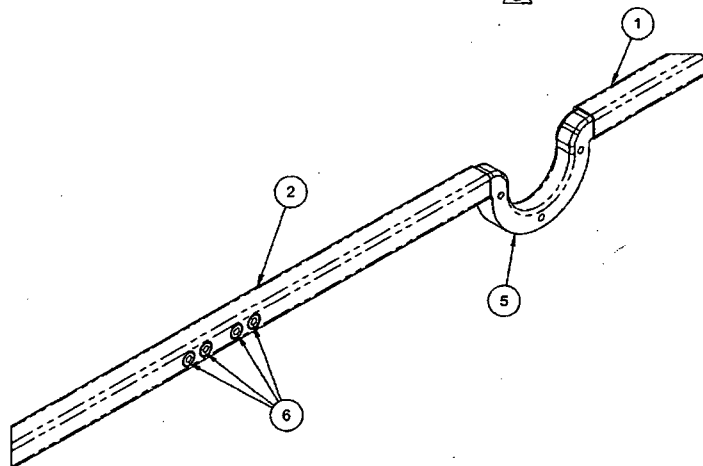
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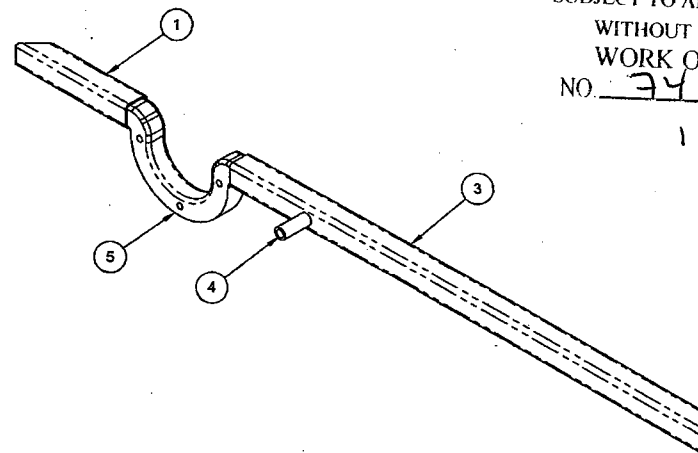
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 7480642J

11/10/06

RELEASED
2011-01-18
MB

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4034	SHEET 1 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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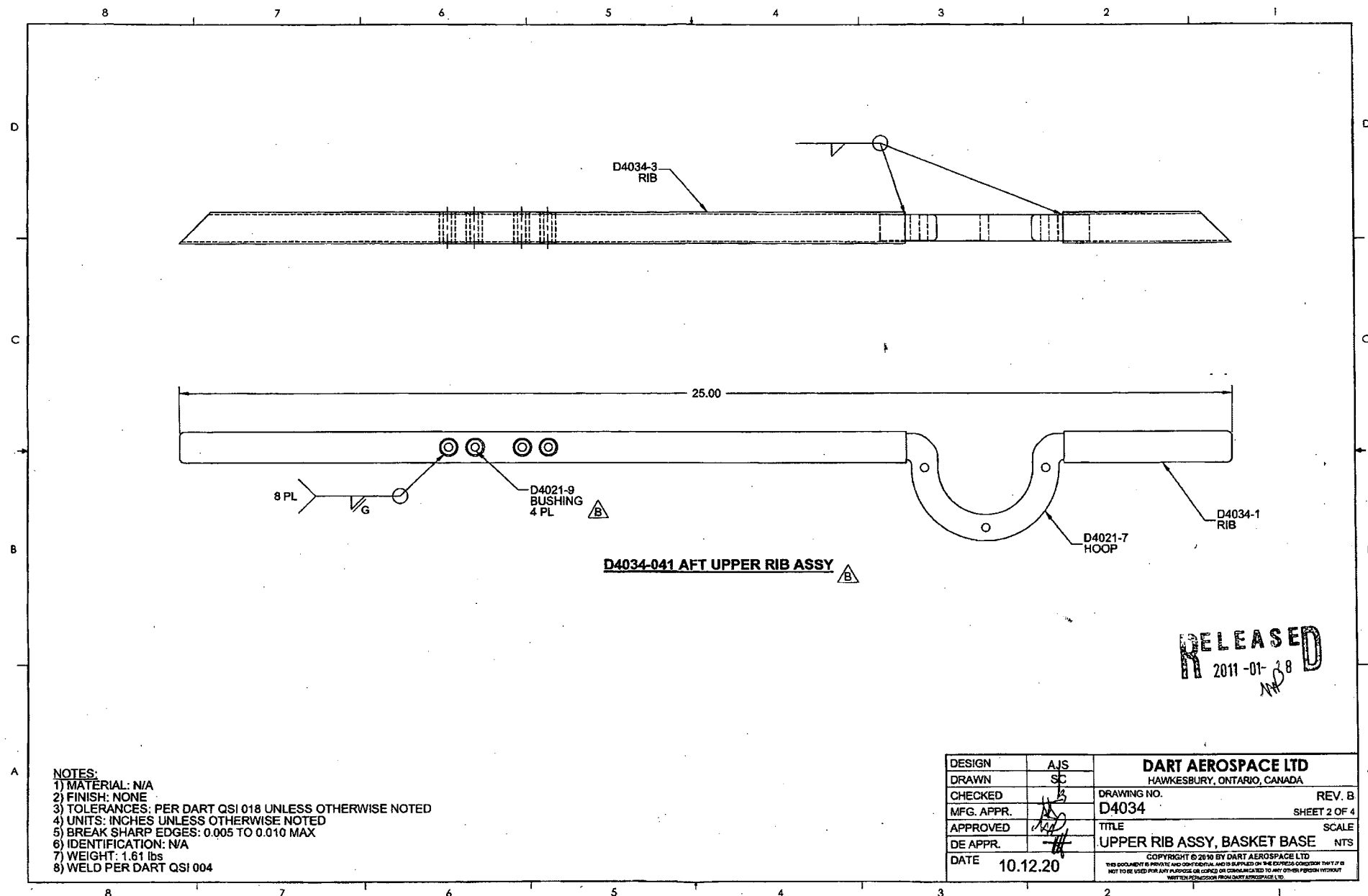
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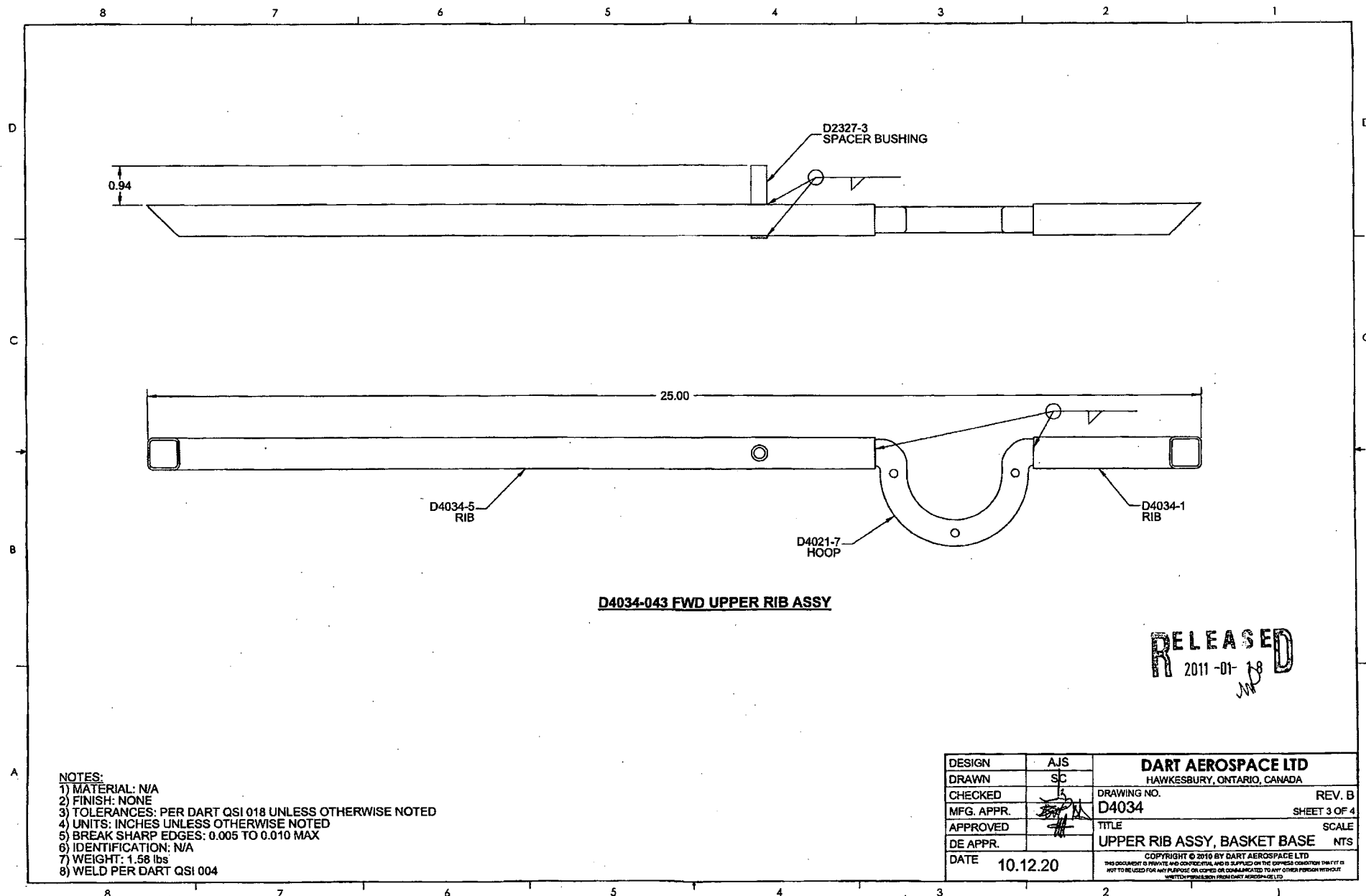
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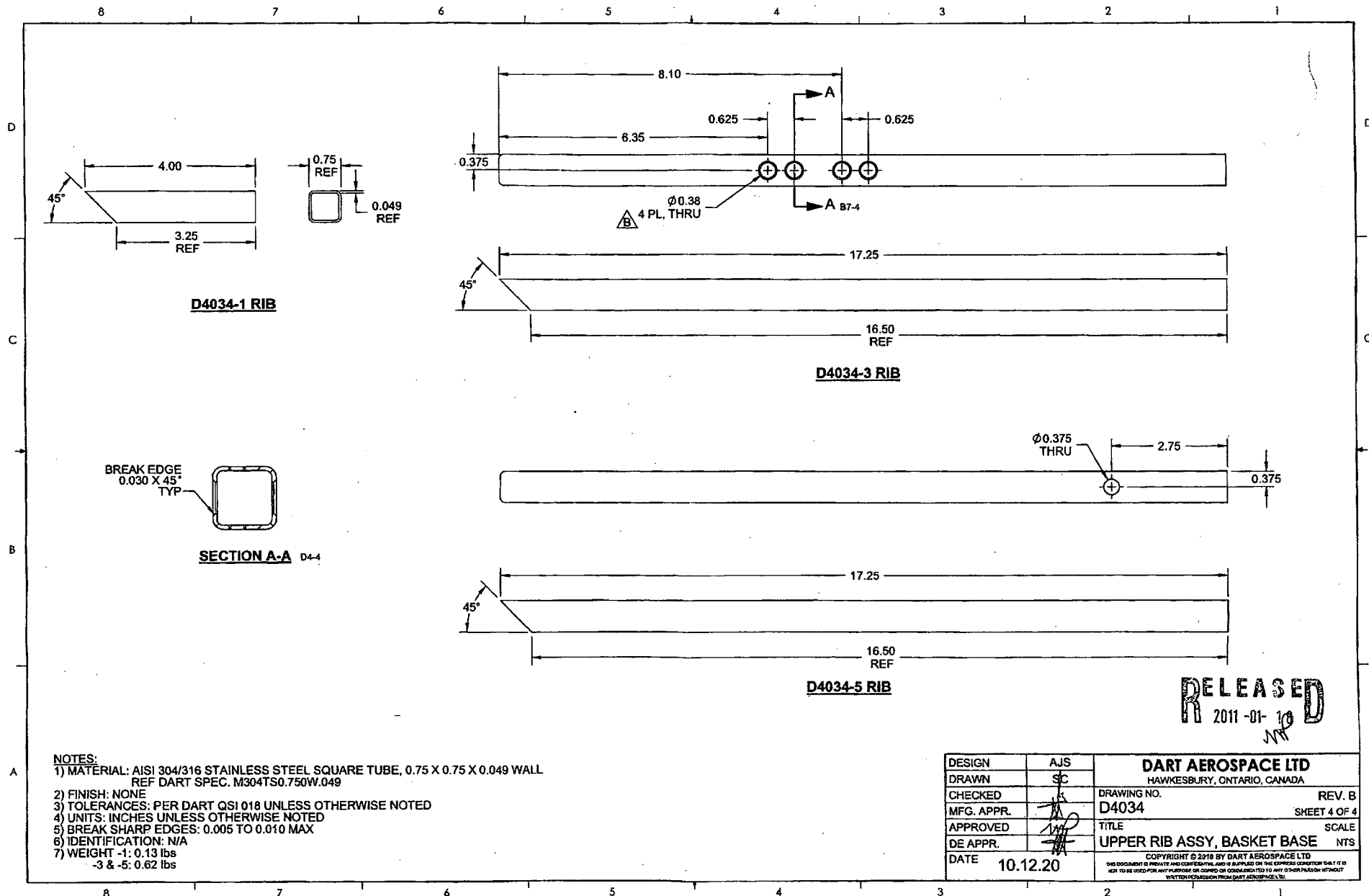
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